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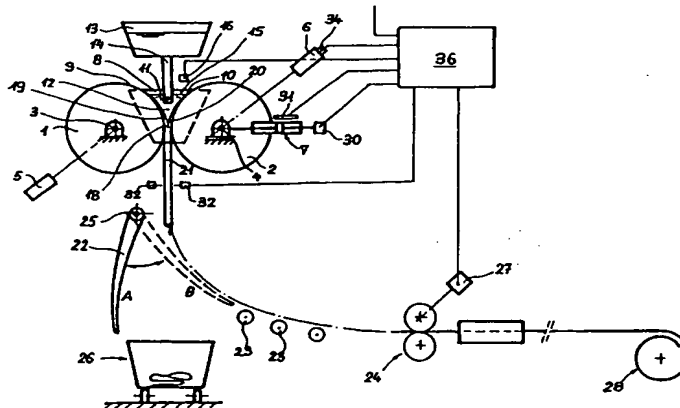
(74) Anwalt: VA TECH PATENTE GMBH & CO.; Zusammenschluss Nr. 169, A-4031 Linz (AT).

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[Fortsetzung auf der nächsten Seite]

(54) Title: METHOD AND DEVICE FOR COMMENCING A CASTING PROCESS

(54) Bezeichnung: VERFAHREN UND VORRICHTUNG ZUM STARTEN EINES GIESSVORGANGES



(57) Abstract: The invention relates to a method for improving the conditions at the commencement of a casting process in a twin-roll casting device, which does not use a dummy bar, said method comprising the following steps: an operating casting thickness is set and the casting rolls are rotated at a casting-roll peripheral speed, which corresponds to a reduced commencing casting speed in relation to the casting speed for stationary operation; molten metal is fed into one of the rotating casting rolls and into the molten metal chamber that is configured from lateral plates lying against the rolls and a cast metal bar with an essentially constant, predetermined cross-sectional size is formed, whilst the casting speed is simultaneously increased to a strip forming casting speed; the casting speed is subsequently increased to a strip separating speed, which is significantly higher than the speed sufficient to cause solidification and the metal strip that has been cast up to this point is separated; the stationary operation casting speed is set; the following cast metal strip is deviated onto a strip transport unit and the stationary casting operation commences. The invention also relates to a twin-roll casting device for carrying out said method.

(57) Zusammenfassung: Zur Verbesserung der Bedingungen beim Starten eines Giessvorganges in einer Zweiwalzengiesseinrichtung ohne Anwendung eines Anfahrstranges wird ein Verfahren mit folgenden Schritten vorgeschlagen: - Einstellen einer Betriebs-Giessdicke und Rotieren der Giesswalzen mit einer Giesswalzen-Umfangsgeschwindigkeit, die

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INTERNATIONAL SEARCH REPORT

International Application No.

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A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 B22D11/16 B22D11/06

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B22D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP 0 867 244 A (BHP STEEL JLA PTY LTD ; ISHIKAWAJIMA HARIMA HEAVY IND (JP)) 30 September 1998 (1998-09-30) column 2, line 22 -column 4, line 2; figures 1-7	1-21
A	EP 0 903 190 A (BHP STEEL JLA PTY LTD ; ISHIKAWAJIMA HARIMA HEAVY IND (JP)) 24 March 1999 (1999-03-24) '0003!', '0023!', '0026! figures 1,2	1-21
A	WO 01 21342 A (BHP STEEL JLA PTY LTD ; ISHIKAWAJIMA HARIMA HEAVY IND (JP); OSADA S) 29 March 2001 (2001-03-29) page 13 -page 15; figures 1,2	1-21
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☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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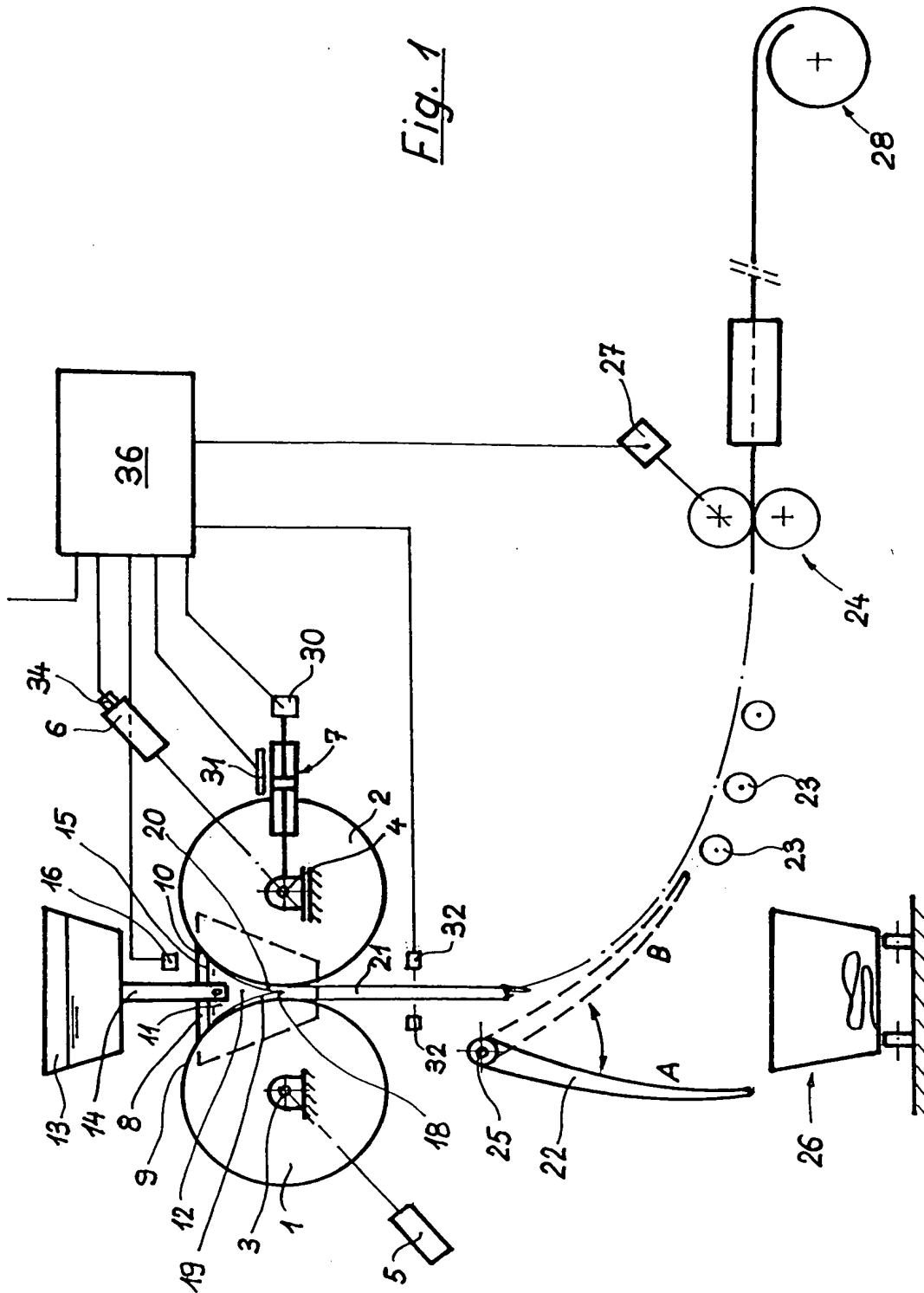
Fig. 1

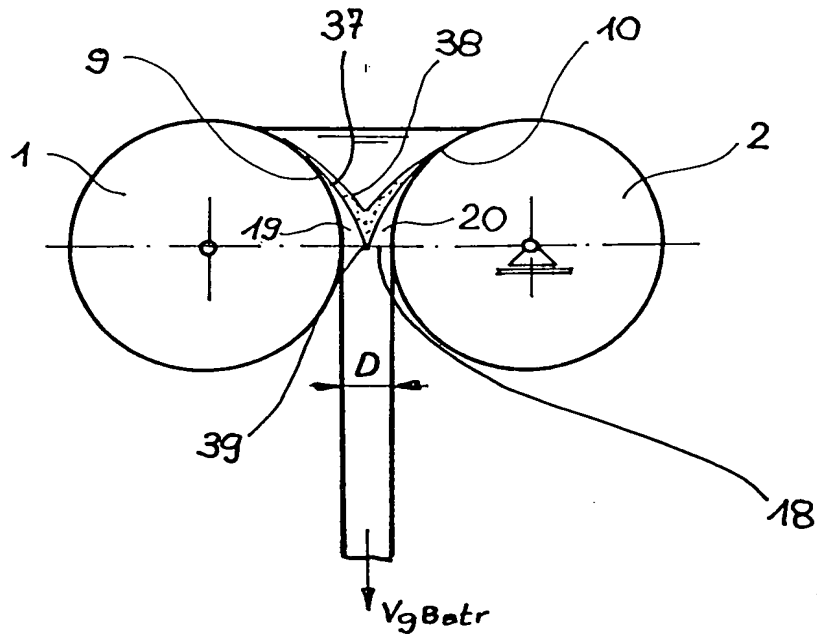
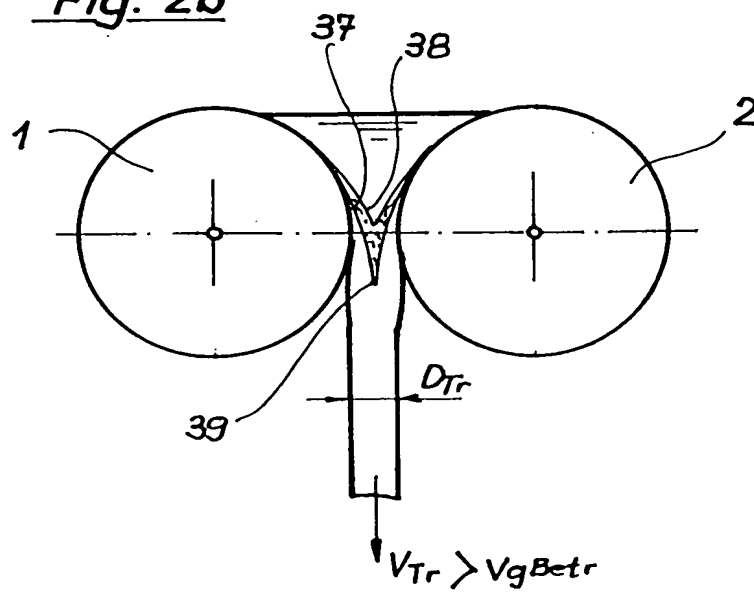
Fig. 2aFig. 2b

Fig. 3